

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022754**Date Inspected:** 03-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in the Bay 10:

SAW welding of weld joint BK17B-001-020 located on PCMK OBG bike path cantilever beam. Welder was identified as 050295. QC was identified as ZPMC CWI Li Jun (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2221-TC-U4a-S-3 as verbally identified by QC1.

SMAW welding of weld joints BK17C-001-065 located on PCMK OBG bike path cantilever beam. Welder was identified as 057220. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U4c as verbally identified by QC1. See photo below of the welding operation in progress.

Heat straightening of 25TR1-002, 004~011, 013, 016 located on PCMK OBG traveler rail. QC was identified as QC1. Heat treatment variables recorded by QC1 appeared to comply with ZPMC document HSR1(B)-10254 as presented to this QA Inspector and verbally identified by QC1. See photo below showing some of the heat straightening operation in progress.

Heat straightening of 28TR1-003, 006~013, 016 located on PCMK OBG traveler rail. QC was identified as QC1. Heat treatment variables recorded by QC1 appeared to comply with ZPMC document HSR1(B)-10186 as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

presented to this QA Inspector and verbally identified by QC1.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

FCAW welding of weld joints SEG3007Q-324, 325; SEG3007S-186; SEG3007N-225, 226 located on PCMK OBG 13AE. Welder was identified as 050242. QC was identified as ABF CWI Bao Qian (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2231-ESAB-repair as presented to this QA Inspector and verbally identified by QCA2.

FCAW welding of weld joints SEG3007S-003; SEG3007Q-100, 114; SEG3007N-249, 250 located on PCMK OBG 13AE. Welder was identified as 055564. QC was identified as . Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2132-ESAB and WPS-B-T-2233-ESAB as presented to this QA Inspector and verbally identified by QCA2.

SMAW welding of weld joints SEG3007J-012; SEG3007G-014 located on PCMK OBG 13AE. Welder was identified as 068924. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-4213-TC-U4b-2 as verbally identified by QCA2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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